

Work Order ID 161891***161891***

Page 1

Tuesday, May 23, 2017 11:00:32 AM

Item ID: D5105-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Handle
Start Date: 5/24/2017 Start Qty: 10.00 ***10*** Cust Item ID:
Required Date: 6/15/2017 Req'd Qty: 10.00 ***10*** Customer:
Reference:

Approvals: Process Plan: DA **DAS 21 9-89** Date: 20170523 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D5105	A								

100
100
Waterjet
FLOW CNC Waterjet
FLOW WATER JET
Memo
1-Cut as per Dwg
Dwg Rev: A
Prog Rev: A
0.00
0.43

****DEBURR BY HAND ONLY****

110
110
QC
Quality Control
QC2- Inspect parts off machine FAI/FAIB
Memo
0.00
0.10

(10) SC 17/06/01
DAS
20
9-89

(10) SC 17/06/01
DAS
20
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	☐ No Re-verification	☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong				
Design ☐	☐ Operator	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions				
Doc/Data ☐	☐ Offset/Setup	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance				
Equip/Tooling ☐	☐ Supplier	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect				
Handling/Pre ☐	☐ Training	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing				
Material ☐	☐ Use for Testing	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved				
Internal Transport ☐	☐ Poor Information	☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing				
Tribal Knowledge ☐	☐ Rushing	☐ Heat Treat	☐ Cut Too Short	☐ Misabeled	☐ Finish				
LOA ☐	☐ Product Improvement	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread				
Substation ☐	☐ Process Improvement	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence				
Past Expiry Date ☐	☐ Manufacturing Process	OTHER :							
Misidentified ☐	☐ Past Due								

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120 *120* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.20				10			DAS 38 9-89 JUN 02 2017
130 *130* Brake NC Brake NC	Bend as per dwg Memo	0.18 0.35			DAS 30 9-89	10			Jar MAY 06 2017
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.20				10			DAS 38 9-89 JUN 06 2017

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180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	1.00							
Quality Control									

DAS
21
9-89

JUN 12 2017

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



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Misidentified ☐	Past Due ☐																																																																

Picklist Print

Tuesday, May 23, 2017 11:00:31 AM

Page 1

Work Order ID: 161891

161891

Parent Item: D5105-1

D5105-1

Parent Item Name: Handle

Start Date: 5/24/2017

Required Date: 6/15/2017

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP REV:A 14.06.18 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.125		Purchased	No			100	sf	71.3970	0.074	0.778947			
M6061T6S 125									**				
6061-T6 .125 Sheet													

Location

Loc Qty

Loc Code

MAT019

67

m136896

35

m137515

32

MAT020

4.397

m136327

4.397

DAS
20
9-89

SC/17/06/01

0,8

DQA: _____ Date: _____

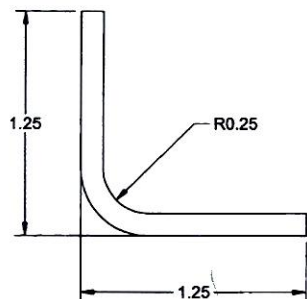
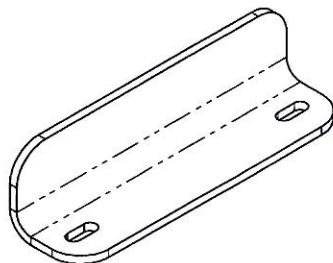


WORK ORDER NON-CONFORMANCE / UPDATE

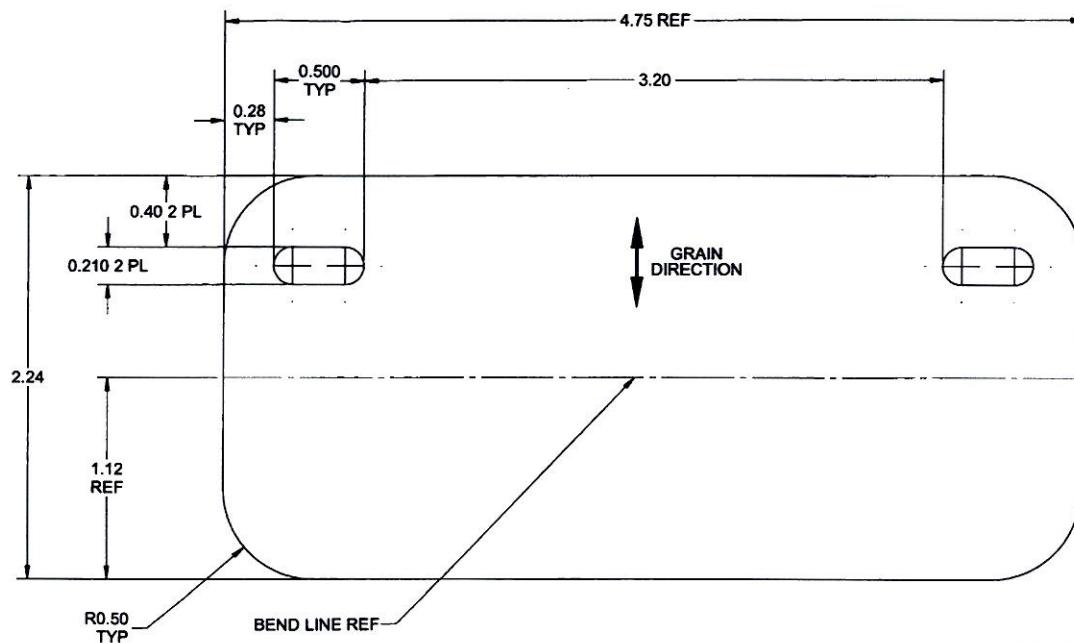
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OTHER : _____									



D5105-1 HANDLE
MAKE FROM D5105-1F



D5105-1F HANDLE
FLAT PATTERN

RELEASED
2014-06-16

- NOTES:**
- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET 0.125 THICK
PER AMS 4025 OR AMS 4027 OR ASTM B209
REF M6061T6S.125
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 METHOD 6.2
 - 7) WEIGHT: 0.12 lbs

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 161 841 20170523

A NEW ISSUE		ML	14.04.21
REV.	DESCRIPTION		BY DATE
DESIGN	ML	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	ML		
CHECKED	AP	DRAWING NO.	REV. A
MFG. APPR.	JLM	D5105	SHEET 1 OF 1
APPROVED	MP	TITLE	SCALE
DE APPR.	DS	HANDLE	NTS
DATE	14.04.21	COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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